

in that the ratio of the difference between the radius of the hem (4) and the thickness of the outermost metal with the thickness of the innermost metal is more than 2.

6. (amended) Assembly process according to Claim 1, characterized in that the nature or thickness of the various parts is not identical for all.

7. (amended) Assembly process according to Claim 1, characterized in that the junction is not rectilinear and has a local curvature, the radius of which is more than at least five times the external radius of the hem (4).

8. (amended) Assembly process according to Claim 1, characterized in that, after said hem crimping, blocking of said hem with respect to the sliding of the assembled parts along the junction section is achieved by bonding, indentation or imbrication.

9. (amended) Product obtained by the assembly process described in Claim 1, characterized in that it has at least two simple sheet metal parts (1, 2, 3; 11, 12, ; 21, 21', 22, 22') in order to create a structural component of open cross section, which is preferably U-shaped, at least one said metal part having a high or very high elastic limit and low formability, characterized in that the metal parts have been formed by at least a bending process and are arranged with respect to each other along a junction section and are assembled with a hem (4) along said junction section, said hem mechanically reinforcing the structure.

11. (amended) Product according to Claim 9, characterized in that

the ratio of the difference between the hem (4) radius and the thickness of the outermost metal with the thickness of the innermost metal is more than 2.

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12. (amended) Product according to Claim 9, characterized in that it is in the form of a two-web I-shaped girder obtained by assembling four constituent parts (21, 21', 22, 22') connected by four hems (4) along the junction section of the four parts taken in pairs.

13. (amended) Product according to Claim 9, characterized in that it results from the assembly of two parts (11, 12) by means of two hems (4) so as to form a closed cross section, at least one of the two parts having a U-shaped cross section.

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